

Work Order ID 101407

101407

Page 1

May-10-13 8:00:40 AM

Item ID: D1038-58B

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Fastener Rail, Black

Start Date: 5/10/13 Start Qty: 50.00

50

Cust Item ID:

Required Date: 5/30/13 Req'd Qty: 50.00

50

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D1038

Rev B

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Create white labels and bag them

110

0.00

110

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut extrusion D2023 to length 21.81" (+0.06/-0.00)

120

0.00

120

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA783 Rev: AA & Dwg D1038 Rev: B
2-Deburr per dwg D1038

JL 13-7-5

OK/MH 51 50 13/05/22

OK/MH 50 113/05/27

CFC 20130528

P70

NCR: ☒ Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA 13/05/27 Date: 13/05/27QA Closed: 13-7-10 Date: 13-7-10

Work Order: <u>101407</u>				DISPOSITION Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS					
Part No. <u>D1038-58B</u>						Skid-tube <input type="checkbox"/> Machining <input checked="" type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>		
NCR No. <u>13-2819</u>											
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/> Equip/Tooling <input type="checkbox"/> Operator <input checked="" type="checkbox"/> Material <input type="checkbox"/> Setup <input type="checkbox"/> Other <input type="checkbox"/> Process <input type="checkbox"/> Supplier <input type="checkbox"/> Training <input type="checkbox"/> Unapproved <input type="checkbox"/>	<u>13/05/27</u>	<u>120</u>	<u>1</u>	Part not placed properly. holes holes do not align. R.C. operator in training	<u>DAS 16</u> <u>Q27042</u> <u>13/05/27</u>	Destroy → Scrap Repace B <u>21907</u> <u>\$41.63</u>	<u>MH/10/1</u> <u>13/05/27</u>	<u>PD</u> <u>13/05/29</u>	<u>DAS 16</u> <u>Q27042</u> <u>13/05/29</u>		
FAULT CATEGORY											
Landing Gear			General								
<input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input checked="" type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio										
			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions								
			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input checked="" type="checkbox"/> Other: <u>R.C. training</u>								

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NS1

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Stop

NS2

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Start Date: 5/10/13

Start Qty: 50.00

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Cust Item ID:

Required Date: 5/30/13

Req'd Qty: 50.00

50

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00	0114	B/05/27		50	1		
140 *140* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	PO	13/05/29		50	0		
150 *150* Small Fab Small Fab Small Fab	Small Fab Memo Debur	0.00 0.00				50x			ES 1306/16

D1038-58B

B101407

REV

Work Order ID 101407

101407

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May-10-13 8:00:40 AM

Item ID: D1038-58B

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Fastener Rail, Black

Start Date: 5/10/13 Start Qty: 50.00

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Cust Item ID:

Required Date: 5/30/13 Req'd Qty: 50.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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180

Receive & Inspect for Damage & Mat'l Certs

0.00

180

Packaging

Memo

0.00

Packaging

50x

SP
13-6-2

190

QC3- Inspect Part Finish

0.00

190

QC

Memo

0.00

Quality Control

DAS
16
13/07/1210/12
(X50)

200

Small Fab

0.00

200

Small Fab

Memo

0.00

Small Fab

1-Stroke .050 stainless steel wire per Dwg D1038-58 using DT8389
 Batch: M120438
 2-Grind wire flush and deburr
 3-Clean

50x

SP
13/07/12

Work Order ID 101407

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Item ID: D1038-58B Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Fastener Rail, Black
 Start Date: 5/10/13 Start Qty: 50.00 *50* Cust Item ID:
 Required Date: 5/30/13 Req'd Qty: 50.00 *50* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210 *210* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				Conts x50 QSP019			
220 *220* Packaging Packaging	Packaging Memo 1-Pack each fastener rail into a cardboard tube 2-Roll Part in foam 3-Install red cap at each end and secure with tape. 4-Apply white labels to cardboard tubes 5-Identify and Stock Location: FG128	0.00 0.00				50x		11.10.13-07-8	
230 *230* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						13/7/8	df

13-07-8

Picklist Print

May-10-13 8:00:40 AM

Page 1

Work Order ID: 101407

Parent Item: D1038-58B

Parent Item Name: Fastener Rail, Black

Start Date: 5/10/13

Required Date: 5/30/13

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP: E 03.05.02 Reformat; Added label KJ/RF
IPP Rev:F 06-08-16 Updated Packaging Procedures JLM
IPP Rev:G 08-09-16 Added Folio # JLM Verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2023 Extrusion, Fastener Rail		Manufactured	No			110	f	815.0000	1.903	95.15			

Location

Loc Qty

Loc Code

MAT006

815

→ 21907

815

100
✱

MH 13/05/22

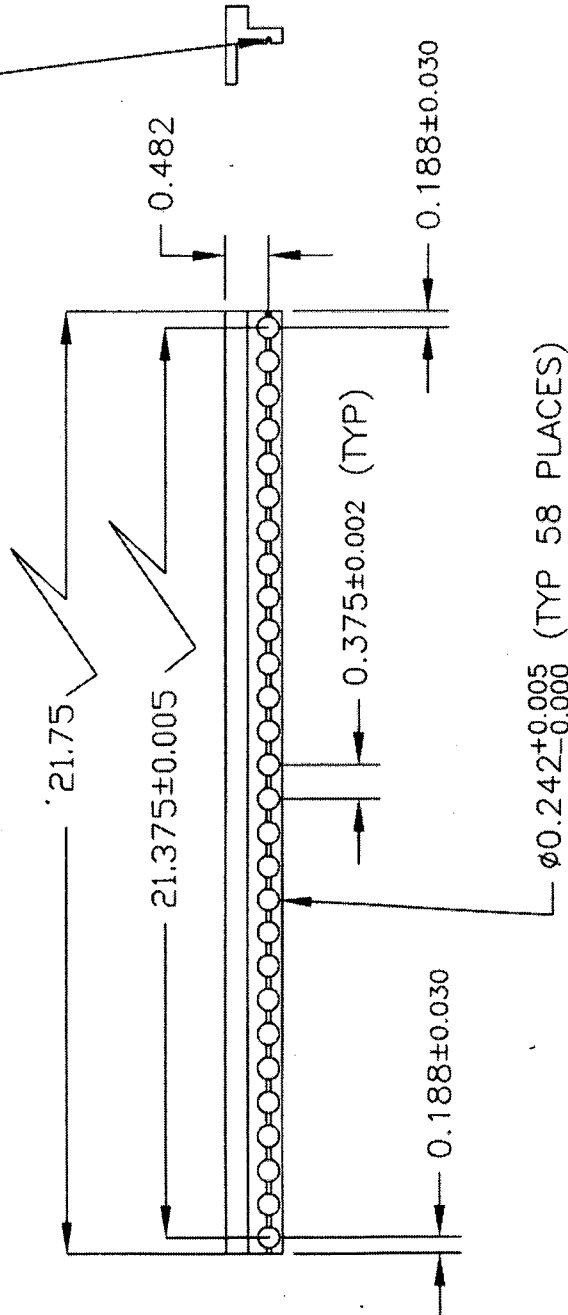
DART

DESIGN 94	DRAWN BY 94	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 94	APPROVED 94	DRAWING NO. D1038	REV. B SHEET 1 OF 1
DATE 05.02.02	TITLE 1/4 TURN FASTENER RAIL		SCALE NTS
	91.05.05	NEW ISSUE	
A	04.05.14	UPDATE TOLERANCE	
B	05.02.02	REDRAWN, UPDATE NOTES	

RELEASED

05.03.31

STAKE $\phi 0.50$ TYPE 302 STAINLESS
STEEL WIRE FULL LENGTH
(REF DART SPEC M302SW.050)



- D1038-58 1/4 TURN FASTENER RAIL
- 1) MAKE FROM D2023 EXTRUSION
 - 2) FINISH: D1038-58 - NONE
D1038-58B - ANODIZE BLACK PER DART QSI 017 4.1.10
 - 3) ALL DIMENSIONS ARE IN INCHES
 - 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W012467

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A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada
Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 62469

Date: 26-Jun-13

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To


DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description	Rev:	
1 lot	Part: ASST 50 PCS D1038-58B BLACK ANODIZE MIL-A-8625 TYPE II CLASS 2 29 PCS 647.9312 HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 PRIME MIL-P-23377J TYPE I CLASS N Job: 20130394	8/13/07/02 Line: SPB-7-2	
Certificate of Conformance			
A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order.			
ISO 9001 : 2008 REGISTERED ATG SALES-2010 TERMS APPLY			
DATE: 26/6/13			
CERTIFIED SIGNATURE: 			
RECEIVER SIGNATURE: _____			



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO20257**

Purchase Order Date 6/20/2013

PO Print Date 6/26/2013

Page Number 1 of 2

Order From :

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

VC-ATG001

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED
6/20/2013

Contact Name
Vendor Phone 613-446-4544

Ship To Contact
Ship To Phone
Ship Via: FedEx PI collect
Ship Acct:

Buyer
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB Destination-Collect

REVISED

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	List Price	Disc %	Discounted Unit Price	Ext. Price
1	101407 FINISH: COLOR BLACK ANODIZE PER MIL-A-8625F TYPE I OR IB/IC/II/IB CLASS 2 (RUSH ORDER)	D1038-58B RAIL	6/28/2013 Yes 6/28/2013		50.00				\$209
Line Total:									\$209
2	100811 FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE I CLASS N	646.2910 DEFLECTOR	6/28/2013 Yes 6/28/2013		8.00				\$0
Line Total:									\$0
3	94748 FINISH SAME AS ABOVE (RUSH ORDER)	647.9312 BRACKET	6/28/2013 Yes 6/28/2013		29.00				\$121

8013-7-2.

Note:

6/26/2013